

Work Order ID 51625

August 27, 2009 8:27:40 AM



Page 1

Item ID: D3436-043

Accept



Setup Start



Revision ID: A

Stop



Item Name: Step LH

Start Date: 8/27/09 Start Qty: 2.00



Cust Item ID:

Required Date: 9/11/09 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

PD

Date: *09-8-27* Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3436

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Weld bushings D3436-5 and clamp D3436-1 using welding Jig DT8772 and
Dwg D3436Dwg Rev: *1* Qty Part Number Description
Batch: A/RN/A 4130 Welding Rod *M19312* Weld
left step D3436-7 using welding Jig DT

EL 9-8-31

110

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

1- Slit part D3436-041 on bandsaw as per Dwg D3436
deburr

12-

EL 9-8-31

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PD 09.09.01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51625

August 27, 2009 8:27:40 AM



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Start Date: 8/27/09 Start Qty: 2.00



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Required Date: 9/11/09 Req'd Qty: 2.00

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Reference:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

=> 8/27/09



QC

Memo

0.00

Quality Control

(X24) φ

140

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

M112260

=> 9/09/09/02



Powdercoat

Memo

0.00

Powder Coating

Apply black anti-skid paint as per Dwg D3436 and QSI 005 4.4 START

TIME: 10:30AM OVEN TEMPERATURE:

11:00AM FINISH TIME: 4:00P

WING WALK

BATCH M112106 EXP DATE 10/30

09-09-3

(24H)

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

2

050904

(151)

Batch D3436-9 per dwg.
B46593

8/30/09/08 (2) (PTC)

W/O: 51625		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09-09-04	150 ↓ 160	- Add a step to bond the D3436-9 part per drawing i. Q51015 (bonding) - And fix routing for pulling part D3436-5 i. D3436-7	CE	09.09.08		09.09.04	09.09.04

Part No: D3436-043 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51625

August 27, 2009 8:27:40 AM



Page 3

Item ID: D3436-043

Revision ID: A

Item Name: Step LH

Start Date: 8/27/09 Start Qty: 2.00

Required Date: 9/11/09 Req'd Qty: 2.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

27 8/27/09

424

9

170



Packaging

Packaging

Identify as per dwg & Stock Location: 203

Memo

0.00

0.00

10/9/08 (2)

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

09/09/08
mf
09-09-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 27, 2009 8:27:39 AM

Page 1

Work Order ID: 51625

Parent Item: D3436-043RevA

Parent Item Name: Step LH


Comments:

Start Date: 8/27/09

Required Date: 9/11/09

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3436-1RevA		Manufactured	No			100	Each	6.0000	2.0000			
												
Clamp												

EL 9-8-28

Warehouse Loc Qty Loc Code
Location

Main Warehouse
ST
46590

6
6

2

D3436-3RevA		Manufactured	No			100	Each	2.0000	2.0000			
												
Left Step												

EL 9-8-28

Warehouse Loc Qty Loc Code
Location

Main Warehouse
ST
44581

2
2

2

D3436-5RevA		Manufactured	No			100	Each	20.0000	8.0000			
												
Bushing												

EL 9-8-28

Warehouse Loc Qty Loc Code
Location

Main Warehouse
ST
46749

20
20

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 27, 2009 8:27:39 AM

Page 2

Work Order ID: 51625

Parent Item: D3436-043RevA

Parent Item Name: Step LH


Comments:

Start Date: 8/27/09

Required Date: 9/11/09

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3436-9RevA		Manufactured	No			100 160	Each	18.0000	4.0000			
												
Pad												

EP 09/09/08

Warehouse Loc Qty Loc Code
Location

Main Warehouse
ST
46593

18
18

D3436-7RevA

Manufactured No



Cap

100
100

Each

14.0000

2.0000

8

EL 9-8-08

Warehouse Loc Qty Loc Code
Location

Main Warehouse
ST
42323

14
14

2

August 27, 2009 8:27:39 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

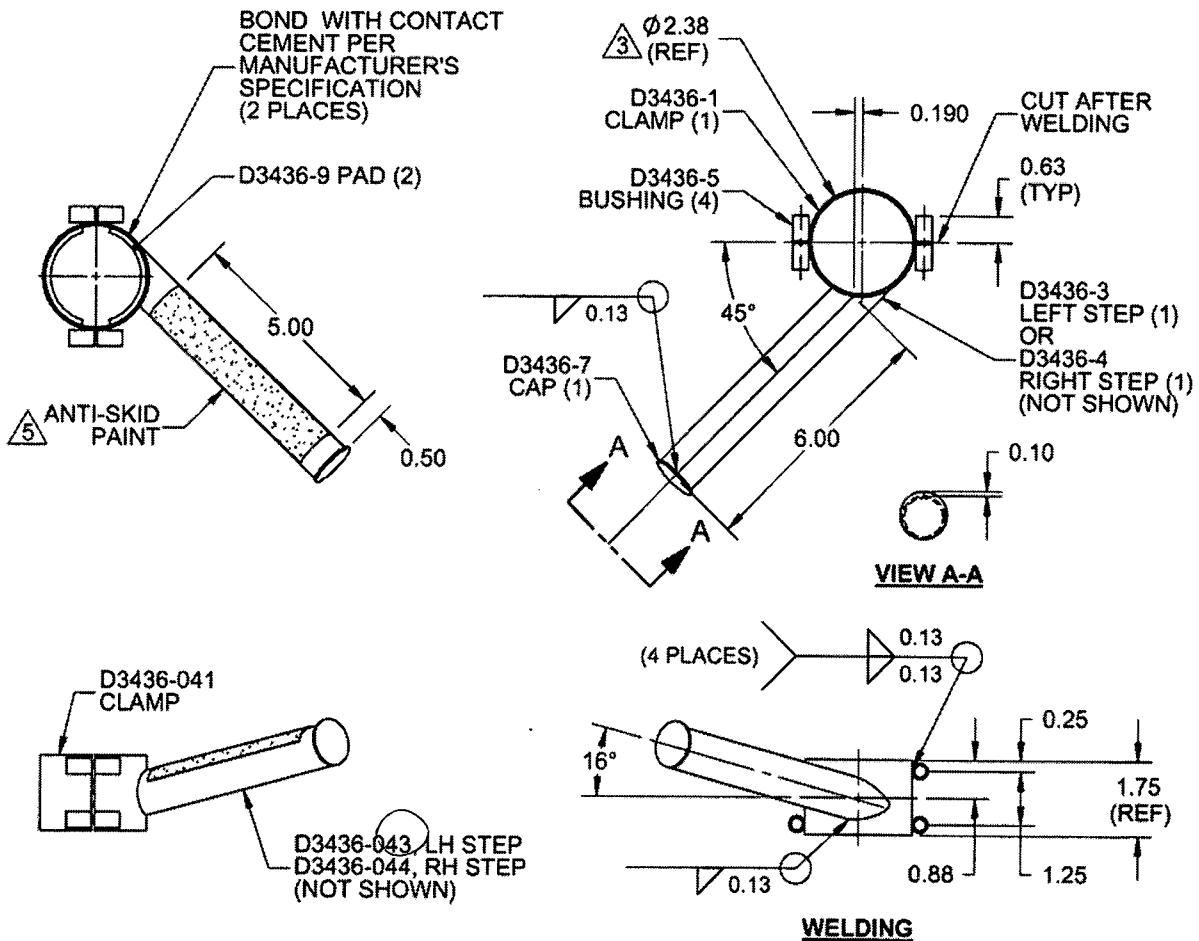
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED //	APPROVED //	DRAWING NO. D3436	REV. A SHEET 1 OF 4
DATE 05.04.28	TITLE MAINTENANCE STEP		SCALE 1:4
A	05.04.28	NEW ISSUE	

**NOTES:**

- 1) POSITION PARTS AS PER JIGS DT8772 AND DT8773
- 2) WELD PER DART QSI 004
- 3) FILLET BOTH TOP AND BOTTOM EDGES OF CLAMP ALONG 2.38 I.D. SECTION TO 0.03 RADIUS TO PREVENT SCORING AND SCRATCHING OF SKID CROSS TUBE
- 4) FINISH: POWDER COAT WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 5) APPLY BLACK ANTI-SKID PAINT AS SHOWN PER DART QSI 005 4.4
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

RELEASED

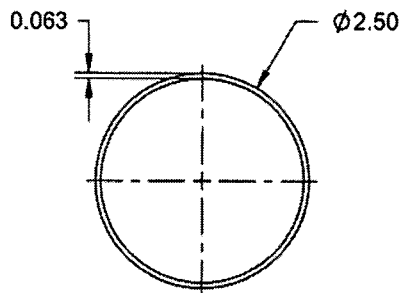
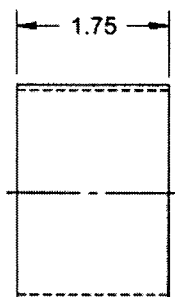
05.05.27

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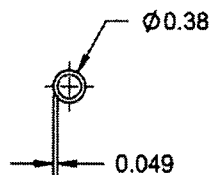
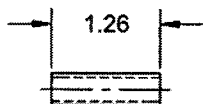


DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3436	REV. A SHEET 2 OF 4
DATE 05.04.28		TITLE MAINTENANCE STEP	SCALE 1:2



D3436-1 CLAMP

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T2500W063)



D3436-5 BUSHING

- 2) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T0375W049)

51625

RELEASED

05-05-27 *[Signature]*

D3436-1/-5, GENERAL NOTES:

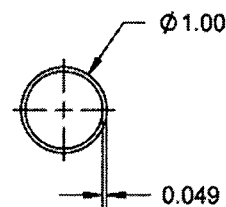
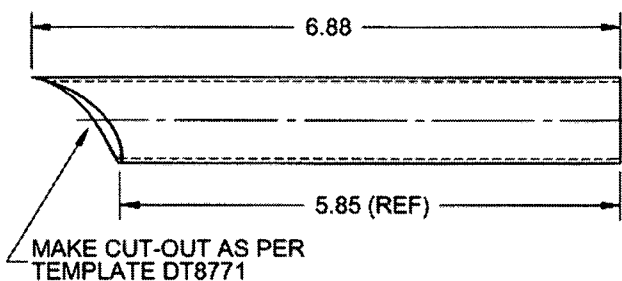
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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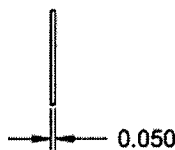
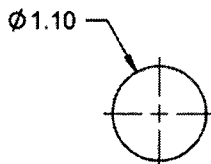
DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3436	REV. A SHEET 3 OF 4
DATE 05.04.28	TITLE MAINTENANCE STEP		SCALE 1:2



D3436-3 LEFT STEP

(D3436-4 RIGHT STEP - OPPOSITE, NOT SHOWN)

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T1000W049)



D3436-7 CAP

- 2) MATERIAL: AISI 4130N STEEL SHEET PER MIL-S-18729, AMS6350 OR AMS 6351 (REF. DART SPEC. M4130N-S050)

RELEASED

05-5-27 *[Signature]*

D3436-3/-7, GENERAL NOTES:

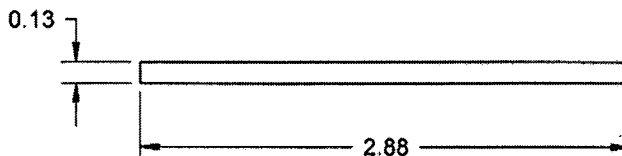
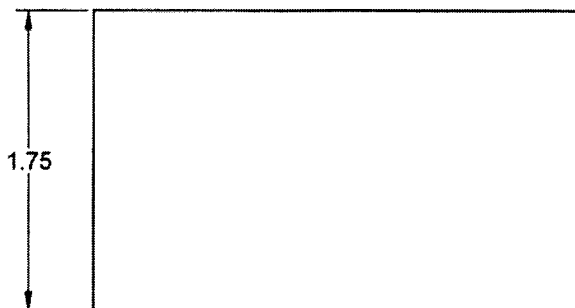
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3436	REV. A SHEET 4 OF 4
DATE 05.04.28		TITLE MAINTENANCE STEP	SCALE 1:1



RELEASED
05.05.27 *[Signature]*

D3436-9 PAD

NOTES:

- 1) MATERIAL: 60 DUROMETER NEOPRENE SHEET, 1/8" THICK
(REF. DART SPEC. M-NEO60-S.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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